

**SIDE GUSSETED POLY BAG WITH A FILLING VALVE
AND ITS METHOD OF MANUFACTURE**

ABSTRACT OF THE DISCLOSURE

A side gusseted poly bag with a filling valve and its method of manufacture including a tubular body with opposed side gussets defining front and rear panels, and a filling valve formed by folding the front and rear panels with the interconnecting gusset portion at one corner of the bag inwardly into the bag forming a filling panel, and simultaneously heat sealing the top edges of the front and rear panels with the top edges of the filling panel forming a filling tube and valve that closes itself under the force of material as it rises in the bag.